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## AMENDMENTS TO THE CLAIMS

1. (Currently Amended) A ~~filled and wound~~ muffler insert for use in a muffler comprising:

a ~~filled insert comprising at least one pipe and a body of wool-type fibrous material conforming to the shape of a compartment in a tool product, said wool-type product surrounding a portion of said at least one pipe; and~~

a yarn thread ~~wrapped wound~~ around the body, thereby confining the volume of the body, and secured to an outer portion of said wool-type product.

2. (Currently Amended) The ~~filled and wound~~ muffler insert of claim 1, wherein at least one of said ~~at least one pipe(s) comprises~~ the muffler insert includes a perforated pipe.

3. (Currently Amended) The ~~filled and wound~~ muffler insert of claim [1] 2, wherein said ~~filled~~ the insert further comprises includes at least one partition(s) coupled to said ~~at least one~~ the pipe.

4. (Currently Amended) The ~~filled and wound~~ muffler insert of claim 3, wherein at least one of said ~~the at least one partitions~~ partition(s) comprises a perforated partition.

5. (Currently Amended) The ~~filled and wound~~ muffler insert of claim 1, wherein said the yarn thread comprises a polymer yarn thread having a tensile strength at room temperature of at least 550 megapascals and having a tensile strength at temperatures greater than about 80 degrees Celsius of at most 50 megapascals.

6. (Currently Amended) The ~~filled and wound~~ muffler insert of claim 5, wherein said the polymer yarn thread is selected from the group consisting of polypropylene yarn thread and modified polyethylene yarn.

7. (Currently Amended) The ~~filled and wound~~ muffler insert of claim 5, wherein said ~~the~~ polymer yarn thread has a fiber diameter of between approximately 0.2 and 1.0 millimeters.

8. (Currently Amended) The ~~filled and wound~~ muffler insert of claim 1, wherein said ~~the~~ yarn thread comprises a steel yarn thread.

9. (Currently Amended) The ~~filled and wound~~ muffler insert of claim 1, wherein said ~~the~~ wool-type product comprises one or more strands of a continuous strand material.

10. (Currently Amended) The ~~filled and wound~~ muffler insert of claim 9, wherein said ~~the~~ continuous strand material comprises one or more strands each comprising a plurality of glass filaments selected from the group consisting of E-glass filaments and S-glass filaments.

11. (Currently Amended) ~~A filled and wound~~ The muffler insert of claim 1 wherein the muffler insert includes a core material, and wherein the body of wool-type fibrous material surrounds at least a portion of the core material comprising:

~~a filled insert comprising a core material and a wool-type product, said wool-type product surrounding a portion of said core material; and  
a yarn thread wrapped around an outer portion of said wool-type product.~~

Claims 12 - 15 (Cancelled)

16. (Currently Amended) A method for forming a ~~filled and wound~~ muffler insert comprising:

~~providing an unfilled muffler insert~~ a tool having one or more compartments;

~~coupling said unfilled muffler insert within a shaped tool, said shaped tool having an upper section and a lower section, said shaped tool and said unfilled muffler insert defining at least one compartment there between;~~

~~introducing a fibrous material within one of said at least one of the compartments~~ compartment to form a filled insert wool-type fibrous body;

~~placing said filled insert~~ the tool onto a winding machine, ~~said winding tool defining a center axis;~~

~~moving said upper section of said shaped tool away from said lower section along said center axis to create a gap;~~

~~wrapping a yarn thread around at least a portion of the body to form the muffler insert~~ said filled insert exposed within said gap to form the filled and wound muffler insert;

~~removing said shaped the tool and the filled and wound muffler insert from said winding tool~~ the winding machine; and

~~extracting the filled and wound muffler insert from said the shaped tool.~~

17. (Currently Amended) The method of claim 16, wherein introducing a fibrous material comprises:

~~introducing a nozzle of a texturizing device within a fill opening of said the shaped tool; and~~

~~introducing one or more strands of a continuous strand material from said the texturizing device through said the nozzle and into said the compartment under vacuum pressure.~~

18. (Currently Amended) The method of claim 16, wherein wrapping a yarn thread comprises:

coupling ~~said the~~ yarn thread contained on ~~said the~~ winding machine to a gripper ~~located at a position near said gap~~;

rotating a portion of ~~said the~~ winding machine around ~~said the tool~~ filled insert such that ~~said the~~ yarn thread is wound onto ~~said the body of fibrous material to form the muffler insert filled insert~~; and

cutting ~~said the~~ yarn thread between ~~said the muffler~~ filled insert and ~~said the~~ winding machine.

19. (Currently Amended) The method of claim 18 further comprising affixing ~~said the~~ yarn thread around ~~said to the muffler~~ filled insert.

20. (Currently Amended) The method of claim 19, wherein affixing ~~said the~~ yarn thread around ~~said filled to the muffler~~ insert comprises affixing ~~said the~~ end of ~~the yarn~~ to ~~said another portion of said the~~ yarn thread.

21. The method of claim 20, wherein affixing ~~said the~~ end comprises ultrasonically welding ~~said the~~ end to ~~said another portion of said the~~ yarn thread.

22. The method of claim 20, wherein affixing ~~said the~~ end comprises hot welding ~~said the~~ end to ~~said another portion of said the~~ yarn thread.

23. The method of claim 20, wherein affixing ~~said the~~ yarn thread around ~~said filled to the muffler~~ insert comprises knotting ~~said the~~ end of ~~said the~~ yarn thread to ~~said another portion of said the~~ yarn thread.

24. The method of claim 19, wherein affixing said the yarn thread around said-filled to the muffler insert comprises affixing said the end within said-fibrous portion the body of fibrous material.

25. (Currently Amended) A method for forming an ~~odd-shaped~~ a muffler comprising:

providing an unfilled muffler insert;

coupling a ~~shaped~~ tool around a portion of said the unfilled insert, said the shaped tool having an upper section and a lower section, said the shaped tool and said the unfilled insert defining a at least one compartment there between;

~~forming a filled insert filling the at least one compartment within said shaped tool with a fibrous material such that the material forms a wool-type body within the compartment of the tool~~;

placing ~~said-filled insert the tool~~ onto a winding machine;

moving said the upper section of said the shaped tool away from said the lower section to create a gap;

wrapping and securing a yarn thread around a portion of ~~said-filled insert the~~ body of fibrous material exposed within said the gap to form a filled and wound muffler insert;

removing said the shaped tool and ~~said-filled and wound the~~ muffler insert from said the winding tool;

extracting ~~said-filled and wound the~~ muffler insert from said the shaped tool;

and

coupling ~~said-filled and wound the~~ muffler insert within a muffler shell.

26. (Currently Amended) The method of claim 25, wherein forming ~~a filled insert~~ the wool-type body comprises:

introducing a nozzle of a texturizing device within a fill opening of said the ~~shaped~~ tool;

introducing one or more strands of a continuous strand material from said the texturizing device through said the nozzle and into said the compartment under vacuum pressure.

27. (Currently Amended) The method of claim 25, wherein wrapping and securing a yarn ~~thread~~ comprises:

coupling said the yarn ~~thread~~ contained on said the winding machine to said ~~filled insert~~ the body within said the gap;

rotating a portion of said the winding machine around said ~~filled insert~~ the body such that said the yarn ~~thread~~ is wound onto said ~~filled insert~~ the body; and

cutting said the yarn ~~thread~~ between said ~~filled insert~~ the body and said the winding machine; and

securing said the yarn ~~thread~~ around said ~~filled insert~~ the body.

28. (Currently Amended) The method of claim 27, wherein securing said the yarn ~~thread~~ around said ~~filled insert~~ to the body comprises affixing said the end of the yarn to said another portion of said the yarn ~~thread~~.

29. The method of claim 28, wherein affixing said the end comprises ultrasonically welding said the end to said another portion of said the yarn ~~thread~~.

30. The method of claim 28, wherein affixing said the end comprises hot welding said the end to said another portion of said the yarn ~~thread~~.

31. The method of claim 27, wherein securing ~~said~~ the yarn thread around ~~said~~ the filled insert comprises knotting ~~said~~ the end to said another portion of ~~said~~ the yarn thread.

32. (Currently Amended) The method of claim 25, wherein coupling ~~said~~ filled and wound the muffler insert within a muffler shell comprises:

- providing a muffler shell having a pair of open ends and an interior region;
- providing a pair of end pieces;
- pressing ~~said~~ filled and wound the muffler insert through ~~said~~ the open end and within ~~said~~ the interior region;
- coupling one of ~~said~~ the pair of end pieces to one of ~~said~~ the pair of open ends;
- coupling the other of ~~said~~ the pair of end pieces to the other of ~~said~~ the pair of open ends;
- sealingly affixing ~~said~~ the one of ~~said~~ the pair of end pieces to ~~said~~ the one of ~~said~~ the pair of open ends; and
- sealingly affixing ~~said~~ the other of ~~said~~ the pair of end pieces to ~~said~~ the other of ~~said~~ the pair of open ends.

33. (Currently Amended) The method of claim 25, wherein coupling ~~said~~ filled and wound the muffler insert within a muffler shell comprises:

- providing a muffler shell having an interior region and a first end and second end; and
- coupling ~~said~~ the muffler shell around ~~said~~ filled and wound the muffler insert such that ~~said~~ filled and wound the muffler insert is substantially contained within ~~said~~ the interior region and such that ~~said~~ the first end substantially abuts ~~said~~ the second end; and
- sealingly affixing ~~said~~ the first end to ~~said~~ the second end.

34. (Cancelled)

35. (New) The method of claim 16 wherein at least one of the one or more compartments includes a perforated pipe.

36. (New) The method of claim 25 wherein the muffler insert includes a perforated pipe.



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